

Work Order ID 53403

November 03, 2009 3:54:50 PM



Page 1

Item ID:	D2221	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	350 Basket Base					
Start Date:	11/4/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	11/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>h</u>	Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2221	Rev H

100		0.00							
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	Large Fab								
--	-----------	--	--	--	--	--	--	--	--

Large Fab		0.00							
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Large Fab									
-----------	--	--	--	--	--	--	--	--	--

Memo

- 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 + DS19473
 - 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
 - 3- tack weld mesh on basket as per dwg D2221
- A/R ER316 S.S. Rod Batch: 24109213

110		0.00							
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	QC9- Inspect visual per QSI004- Fusion Welds								
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QC		0.00							
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Quality Control									
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Memo

11/09/11/10 (1x)

see Enc C

Cpl 09 11 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



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Item ID: D2221 Accept  Setup Start 
Revision ID: H Stop 
Item Name: 350 Basket Base
Start Date: 11/4/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 11/11/2009 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>BR</i>	<i>09-11-11</i>		<i>①</i>			
							<i>PHN 53403</i>		
150  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>09/11/12</i> <i>ME 09-11-12</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 53403

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Comments:

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2221-1RevH  Rib		Manufactured	No			100	Each	23.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

22

51872

10

53213

12

SAD 09-11-10

✓ D2221-5RevH

Manufactured

No

100

Each

6.0000

2.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

53131

6

2x

✓ D2221-7RevH

Manufactured

No

100

Each

3.0000

1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

3

51251

3

1x

SAD 09-11-10

SAD 09-11-10

09/11/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 53403

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Comments:



Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2232-3RevC		Manufactured	No			100	Each	7.0000	2.0000			
										SAD	09-11-10	
Basket Hinge												

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
50024
51870

B53344 ——— 2x
7
2
5

SY 09/11/06

D2235-1RevB1		Manufactured	No			100	Each	16.0000	2.0000			
										SAD	09-11-10	
Basket Rib												

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
51438
Main Warehouse
WA
50565
51871

3
3
13
3
10

2x SY 09/11/06

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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November 03, 2009 3:54:49 PM

Work Order ID: 53403

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base



Comments:

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1 ✓  Mounting Bracket		Manufactured	No			100	Each	56.0000	2.0000 	SAD	09-11-10	

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	12	
46086	2	
48428	1	
51120	9	

Main Warehouse

WA	44	
50872	1	
51745	43	

D3442-1RevA

Manufactured No

100

Each

14.0000

2.0000

✓ 

Shim



2x SY 09/11/06
SAD 09-11-10

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	1	
46767	1	

Main Warehouse

WA	13	
50951	13	

2x SY 09/11/06

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Work Order ID: 53403

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Start Date: 11/4/2009

Required Date: 11/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured	No			100	Each	4.0000	2.0000			
												
Rib Assembly (Basket End)												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

353381 x 2

ST

4

51869

4

D3826-041RevB

Manufactured

No

100

Each

4.0000

2.0000



Rib / Gusset Assembly



SAD 09-11-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

53216 — 2x

ST

4

51340

4

D3827-041RevA

Manufactured

No

100

Each

3.0000

1.0000



Rib Assembly (Inboard)



SAD 09-11-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

51339

3

53247 — 1x

SAD 09/11/06

November 03, 2009 3:54:49 PM

Shop Packet Print

Page 4

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Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Start Date: 11/4/2009

Required Date: 11/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-1RevA  Mesh (Base)		Manufactured	No			100	Each	4.0000	1.0000			

SAP 09-11-10

Warehouse Loc Qty Loc Code

Location

Main Warehouse

B53218 X 1

ST

2

46306

1

46774

1

Main Warehouse

WA

2

51863

2

D3833-1RevA

Manufactured

No

100

Each

12.0000

2.0000



Mesh (Base End Face)

SAP 09-11-10

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

51304

4

Main Warehouse

WA

8

50025

2

53214

6

2

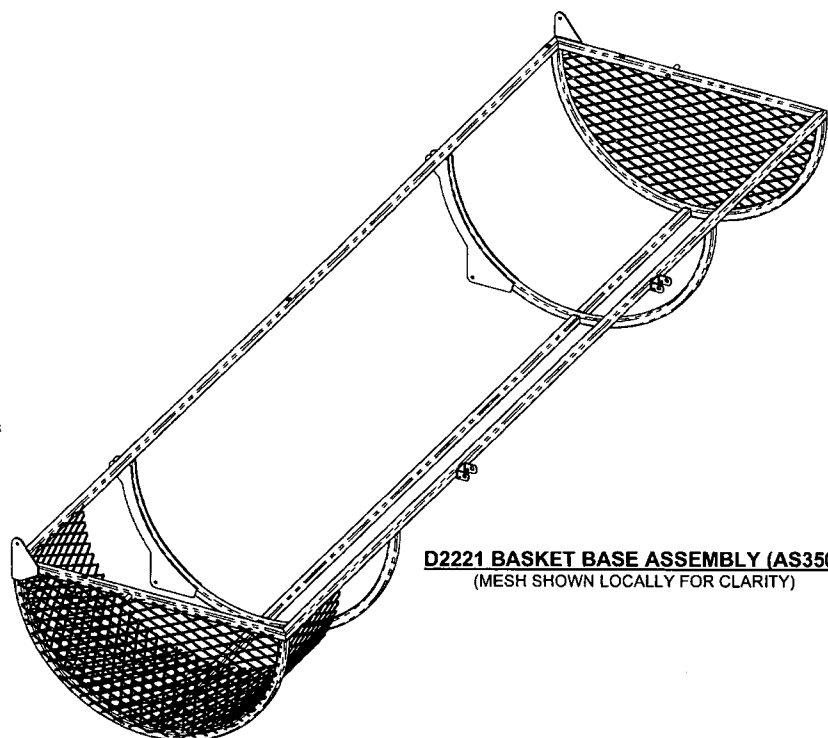
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

53403

RECEIVED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	AS	D2221	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1984 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON "THE EXPRESS BOND" THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

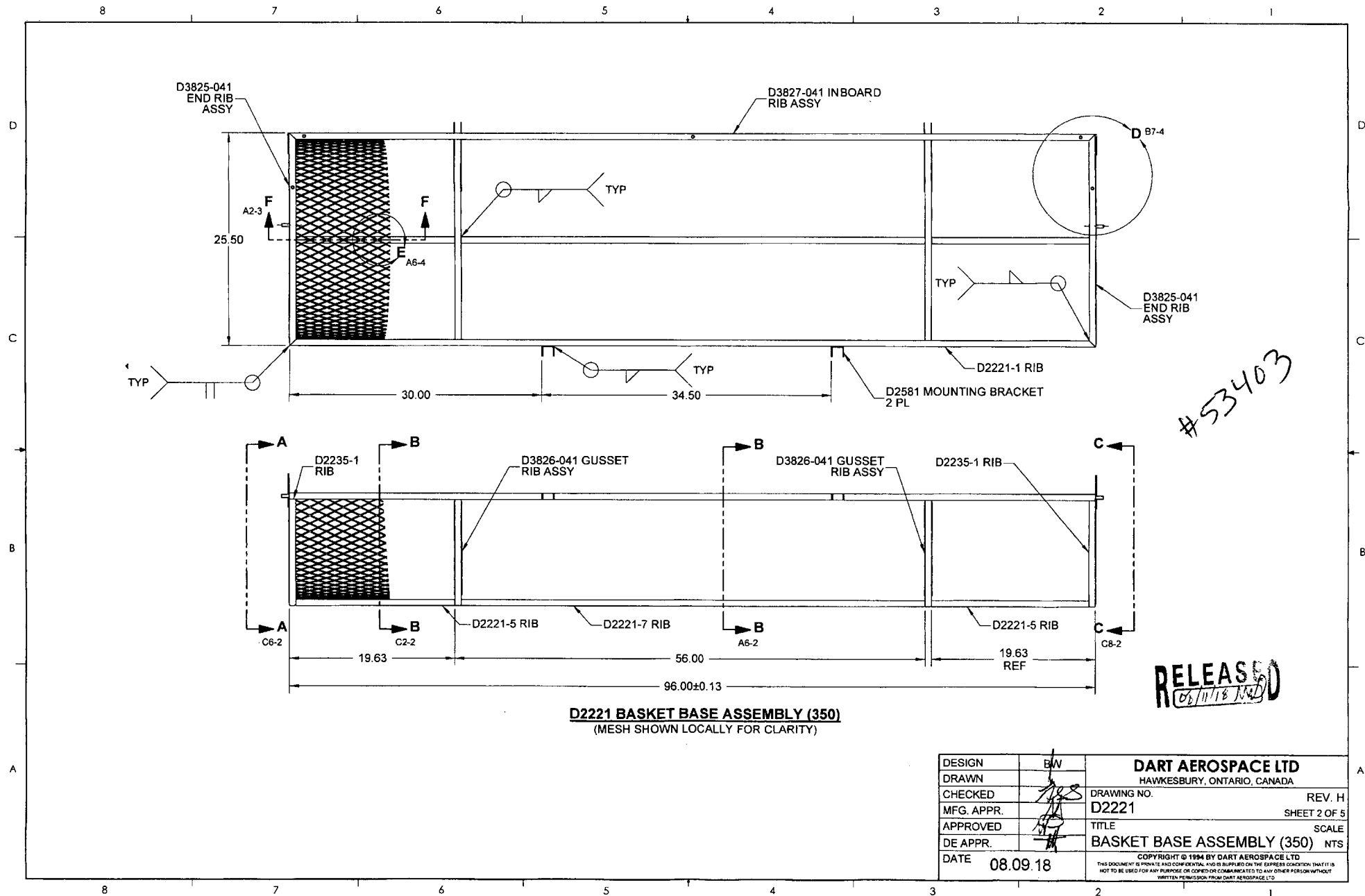
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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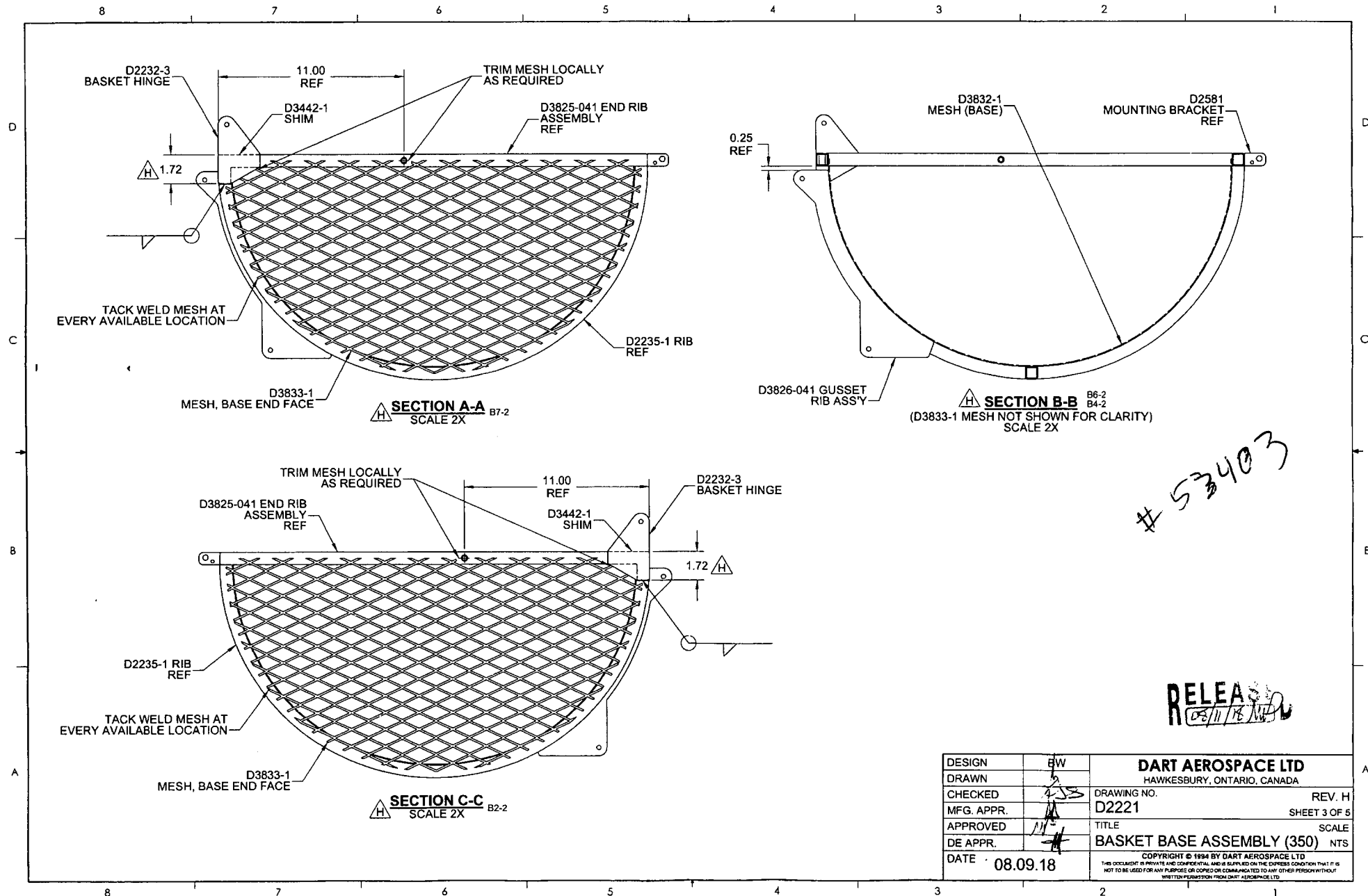
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#53403

RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	133	HAWKESBURY, ONTARIO, CANADA	
CHECKED	133	DRAWING NO. D2221	REV. H
MFG. APPR.	133	TITLE	SHEET 3 OF 5
APPROVED	133	BASKET BASE ASSEMBLY (350)	SCALE NTS
DE APPR.	133	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
DATE	08.09.18	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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8 7 6 5 4 3 2 1

D

C

B

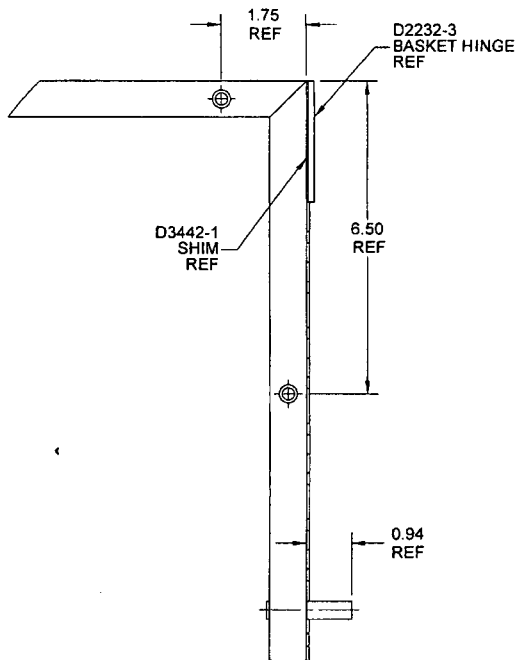
A

D

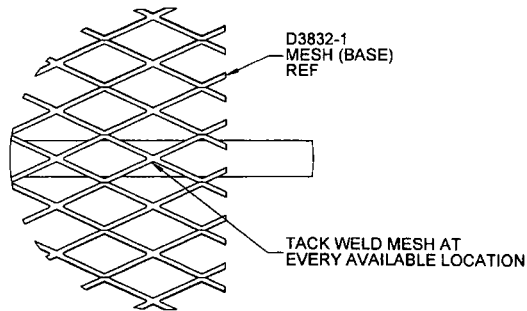
C

B

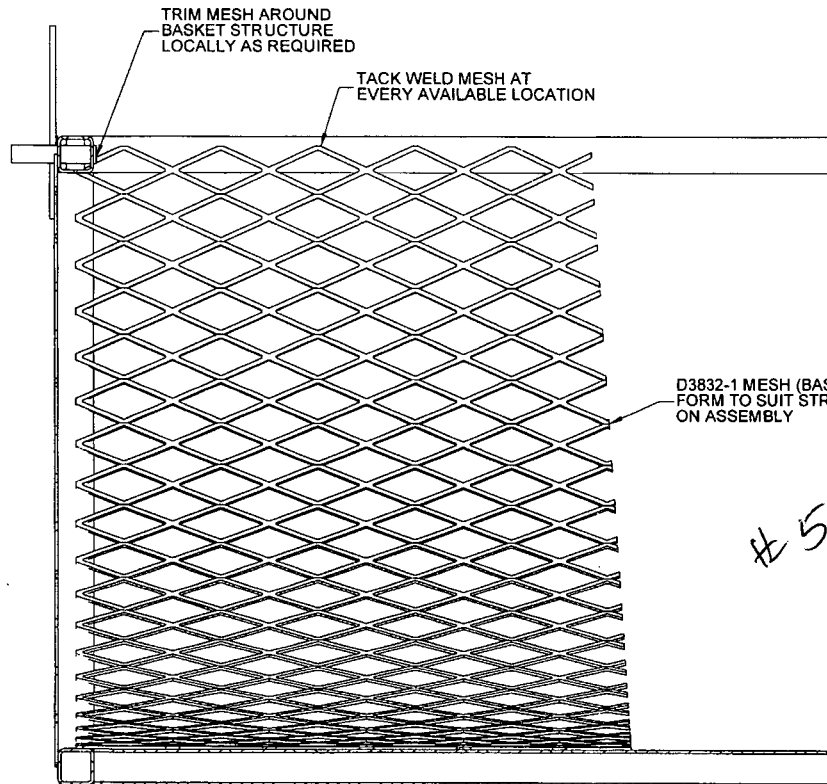
A



DETAIL D
SCALE 4X D2-2



DETAIL E
SCALE 4X C6-2



SECTION F-F
SCALE 4X D7-2

#53403

RELEASED
08/11/8 MP

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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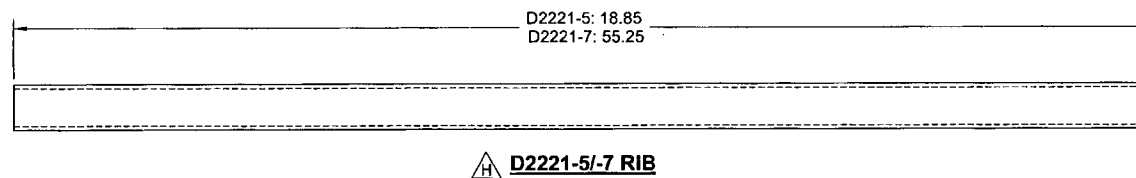
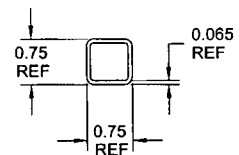
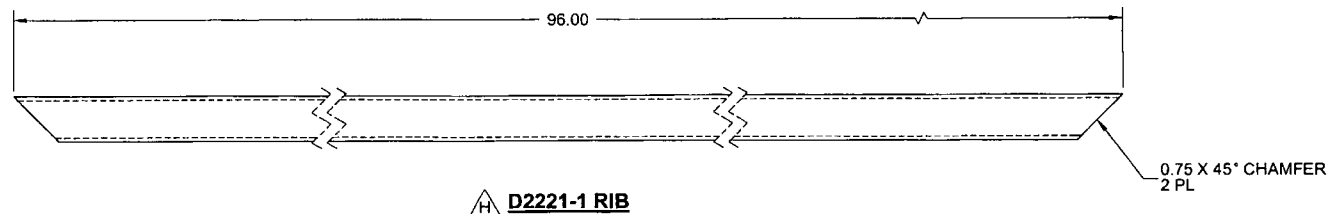
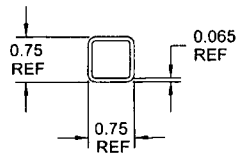
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RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PS	DRAWING NO.	REV. H
MFG. APPR.	MD	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	W	BASKET BASE ASSEMBLY (350)	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries